

Work Order ID 70555

Friday, June 10, 2011 3:42:19 PM



Page 1

Item ID: D350-578-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 6/10/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2672	Rev B1								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-021 CHG005

S. Walker

After BG 11-9-16

160

0.00



Packaging

Packaging

Memo

0.00

Packaging

Pick: Packing Kit
(Note: D2672B is on the BOM as material from step 3)

P. Walker

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S. Walker

(f4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-021

Identify and Stock

Location: 11A Reva11/9/19 2 40

190

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/9/19 2 40

ME 11-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 70555

Parent Item: D350-578-021

Parent Item Name: Bearpaw






Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B New Manufacturing Method 08-10-29 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2672 		Manufactured	No			100	Each	0.0000	2	8			
Bearpaw 13" X 24", 206 AN4-17A 		Purchased	No			160	Each	566.0000	12	48			
Bolt 													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST358			300						
				116419			0						
				116704			0						
				117514			200						
				117619			100		M117514				
				ST359			266						
				116704			266						
AN960JD416 	NAS1149D0463J	Purchased	No			160	Each	0.0000	24	96			
Washer D2182B 		Manufactured	No			160	f	251.9552	2.5	10			
Rubber Cushion (D2182B050) 6X 5" per kit M11.09.19													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST410			251.95517						
				66063			251.95517		66063				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 70555

Parent Item: D350-578-021

Parent Item Name: Bearpaw

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

D2274 Manufactured No 160 Each 519.0000 12 48



Radius Block

Location	Loc Qty	Loc Code
ST010	519	
68942	219	
69736	200	
69773	100	

69736

D2438 Manufactured No 160 Each 212.0000 6 24



Clamp

Location	Loc Qty	Loc Code
ST456	212	
67830	23	
68673	81	
69737	108	

70693

D2529 Manufactured No 160 Each 323.0000 12 48



Washer

Location	Loc Qty	Loc Code
ST016	323	
66953	323	

73486

MS21042L4 Purchased No 160 Each 5,299.000 12 48



Nut

Location	Loc Qty	Loc Code
ST300	5299	
117441	2999	
117601	800	
117885	1500	

117885

6/15/11 (4)

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Shop Packet Print

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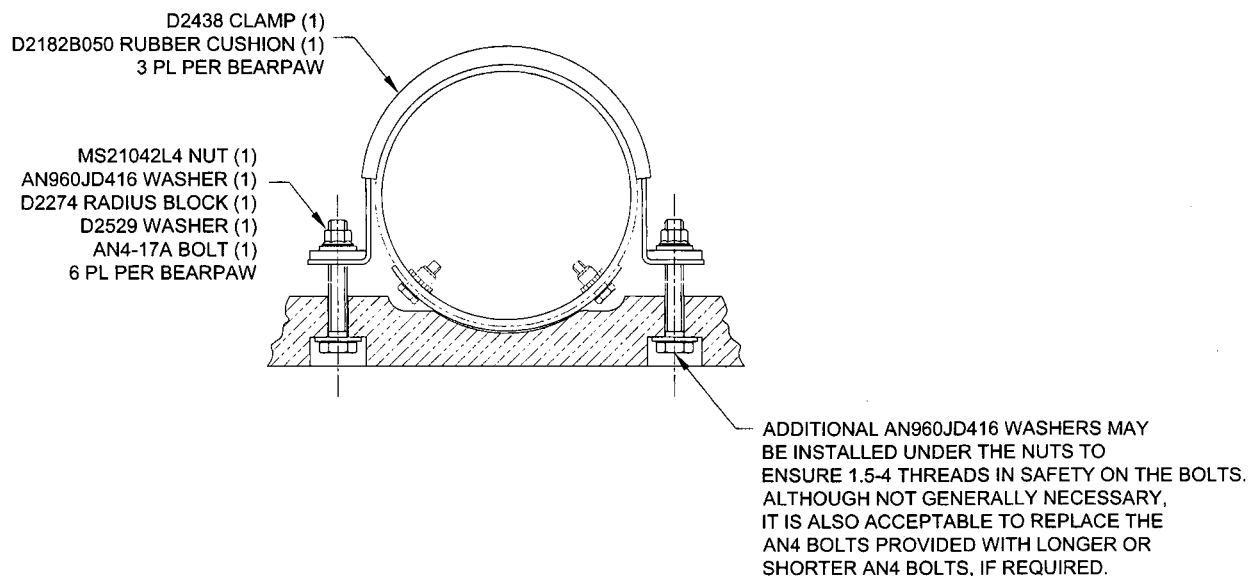
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NOTE: Date & initial all entries



Section A-A
Figure 4 – Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)